

Split

DA T AEROSPACE LTD		Work Order:	24622-1A
Description: Gas Spring		Part Number:	D2807
Dwg: D2807 Rev. C		Qty:	20
Page 1 of 1			

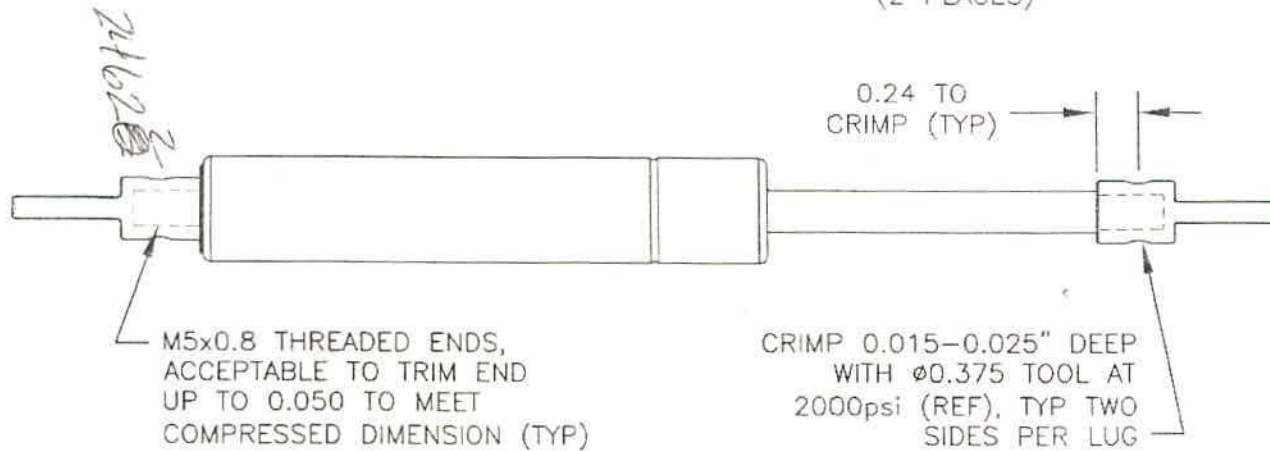
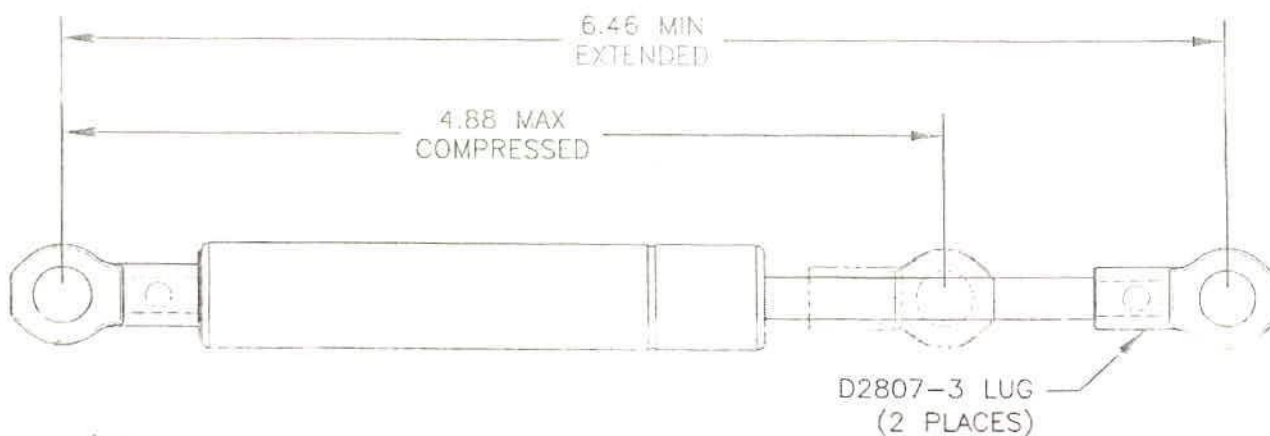
Step	Location	Procedure	Date	Qty
1	DC	Issue Traveler	05.10.21	20
2	PG	Issue P/O: <u>2008847</u> Order as per Dwg D2807 Possible supplier: ArvinMeritor Motion Control Systems Material release note is required	05/10/21	20
3	RG	Receive and Inspect for transit damage Ensure the material release note is attached	05/11/21	20
4	QC6	Inspect dimensions as per Dwg D2807	05.12.21	20
5	GA	Install lugs and crimp as per Dwg D2807: <u>Remove the lugs & key 6</u> Pick: <u>using D2807 Crimp die with WASH. WIRE.</u> Qty Part Number Description Batch 2 D2807-3 Lug B23479	06.01.22	15
6	QC5	Inspect work to Step 5	06.03.16	15
7	ST	Identify and Stock	06.03.16	15
8	AC	Cost / part: 1	06.03.16	15
9	DC	Close W/O Inspect Level 21	06.03.16	15

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Added step 6	EC	
C	05.04.28	Reformat; Added Step 6 & 7	KJ/JLM	
D	05.06.21	Removed painting; Changed supplier	KJ/JLM	

RELEASED
21/05/22

DART

RELEASED
11-05-06-16



DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05.05.25	05.03.16	D2807
DATE	05.05.25	TITLE
		GAS SPRING
A	00.11.03	NEW ISSUE
B	05.03.16	ADD FINISH
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG
		REV. C
		SHEET 1 OF 2
		SCALE
		1:1

D2807 GAS SPRING

- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED

554471001

INVOICE TO:

MALE PERFORMING — 1

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY ON, CANADA
FED EX ECONOMY
ACC 65179834-0
KRA 1K7

DATE _____

199105

17939

AREA

44

CUSTOMER REF. No.

2005547

V.A.T. REGISTRATION No. GB 738 8577 71

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